

Date: Thursday, 8/3/2006 11:09:11 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT
Job Number : 28089	
Estimate Number : 12487	
P.O. Number : N/A	Part Number : D35021
This Issue : 8/3/2006 S.O. No. : N/A	Drawing Number : D3502 PREL
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : PREL
Previous Run : 27874	Material : N/A
Written By : <i>JLM/06-08-03</i>	Due Date : 8/10/2006 Qty: 8 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 06-07-06 JLM	
Note: Estimate is currently made for manual machining .(temp only)	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R325	6061-T6 Round Bar 3.25"
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Comment: Qty.: 0.0893 f(s)/Unit Total: 0.7140 f(s)

6061-T6 Round Bar 3.25"

(M6061T6R325)

Batch: M14306

*[Signature]*

06/08/04

3

2.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE

Turn as pwer Dwg D3502

*[Signature]*

06/08/07

10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*[Signature]*

06/08/07

10

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Mill as per Dwg D3502

*[Signature]*

06/08/08

10

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*[Signature]*

06/08/08

10

6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 06/08/09

10

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 28089

Part Number: D35021

Job Number:



Seq. #: Machine Or Operation: Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Q.M*

*06-08-09*

*(10)*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*Q.M 06-10-02*

*06-10-02*

*(5)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

*ST446*

*04/10/03*

*06/08/09*

*(10)*

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/08/10*

*(10)*

Job Completion

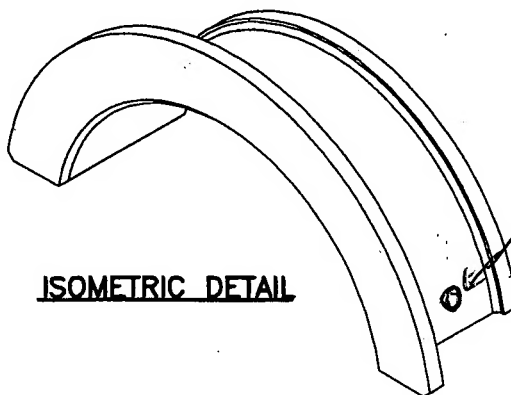


*U 06-08-10*

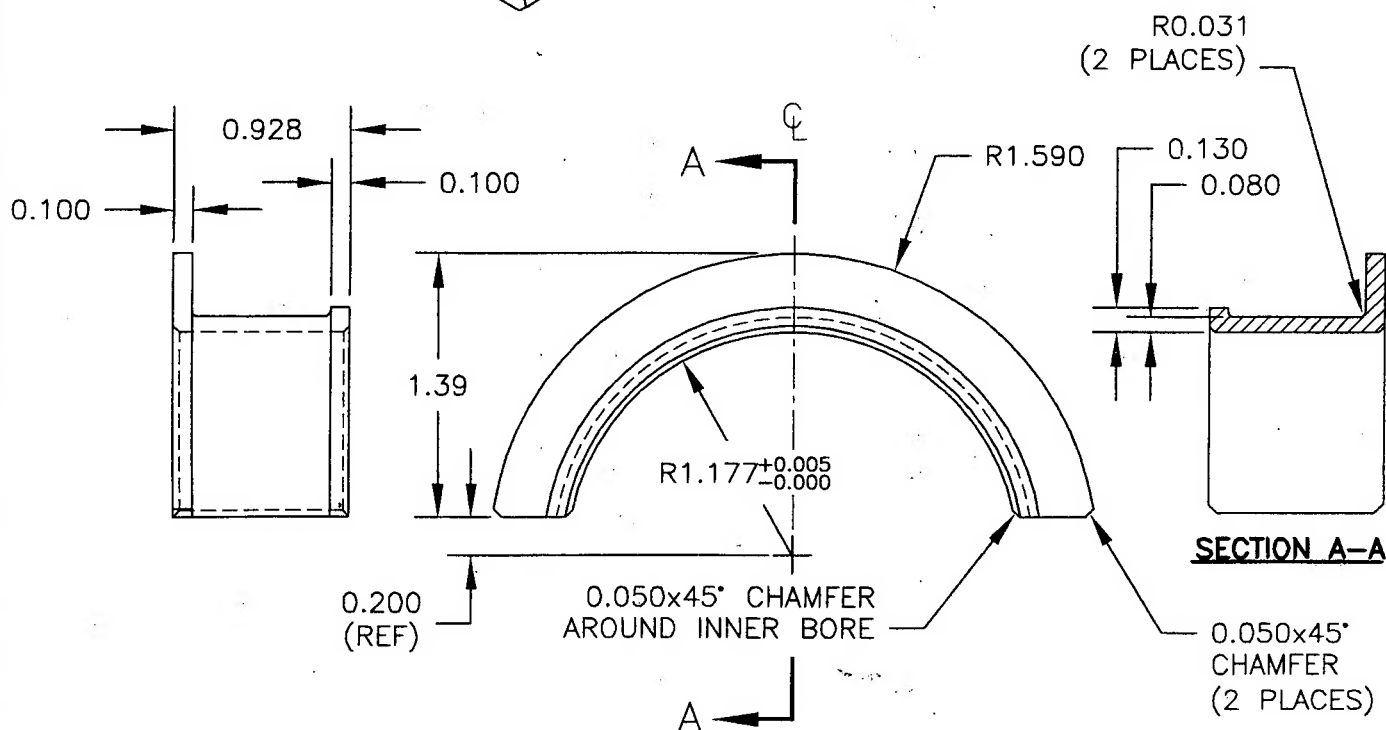
**PRELIMINARY ISSUE**

*P. 06.07.06*

DESIGN <i>QP</i>	DRAWN BY <i>QP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3502	REV. A SHEET 1 OF 1
DATE 06.04.18		TITLE SUPPORT	SCALE 1:1
A	06.04.18	NEW ISSUE	



**ISOMETRIC DETAIL**



## D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX =  $\pm 0.010$ , X.XX =  $\pm 0.030$ ) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06.12.02	3	DRILL 40.058 HOLE 0.175" FROM EDGE FOR HANGING PART DURING POWDER COAT				CP 06.12.02 P QSI 042	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Chris Provencal**

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**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** September 25, 2006 11:45 AM  
**To:** 'Chris Provencal'  
**Subject:** RE: Deviation on D3502-1

This is acceptable.

David

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**From:** Chris Provencal [mailto:cprovencal@dartaero.com]  
**Sent:** Monday, September 25, 2006 8:59 AM  
**To:** David Shepherd (David Shepherd)  
**Cc:** 'S Shahbazian'  
**Subject:** Deviation on D3502-1

David,

The D3502-1 Support for the 350 xtubes, there needs to be a 0.098 tooling hole to hand the part during finishing. I think you are already aware of this, we needed to do this to the preliminary parts. The drawing will be updated to add the optional tooling hole (when we update the xtube drawings for the finish), in the meantime we need permission for the hole.

Chris

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No virus found in this incoming message.  
Checked by AVG Free Edition.  
Version: 7.1.405 / Virus Database: 268.12.6/453 - Release Date: 9/20/2006

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No virus found in this outgoing message.  
Checked by AVG Free Edition.  
Version: 7.1.405 / Virus Database: 268.12.6/453 - Release Date: 9/20/2006

02/10/2006